

Work Order ID 131768

Tuesday, April 21, 2015 1:49:41 PM

131768

Page 1

Item ID: D3912-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Eyebolt Block

Start Date: 4/20/15 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/20/15 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start

NR1Approvals: Process Plan: MCS Date: 15-04-22 Tooling: _____ Date: _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3912	B
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100

Cut blanks as per folio

0.00

100

Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 2.50" LONG

0.00

DAS
20
9-89

15-04-28

110

0.00

110

HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA870 AND DWG

FOLIO REV: AADWG REV: 13

DEBURR

0.00

DAS
20
9-89

15-04-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																														
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Tuesday, April 21, 2015 1:49:41 PM

Page 2

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 131768

Tuesday, April 21, 2015 1:49:41 PM

131768

Page 3

Item ID: D3912-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Eyebolt Block

Start Date: 4/20/15

Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/20/15

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21 - Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MLJ

APR 29 2015

MLJ

APR 29 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____																					

Picklist Print

Tuesday, April 21, 2015 1:49:41 PM

Page 1

Work Order ID: 131768

131768

Parent Item: D3912-3

D3912-3

Parent Item Name: Eyebolt Block

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X1.000		Purchased	No			100	f	11.4500	0.208	2			DAS
										**	1.313'		20
												9-89	1504-28
M303B1 000X1 000													
303 BAR 1" X 1"													

Location

Loc Qty

Loc Code

MAT008

11.45

m126724

0.75

m130013

0.73

m131553

9.97

1.313'

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

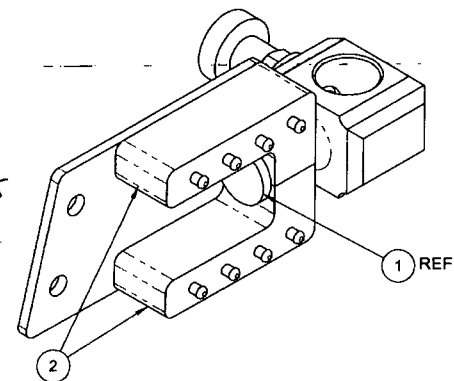
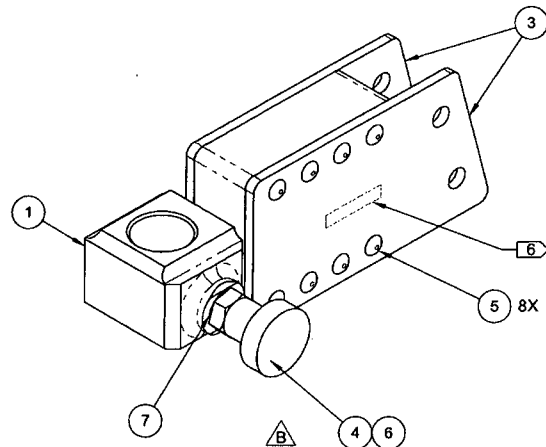
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Date: _____	Step #: _____	QTY Effective: _____		MRB (QSI042) Approval	
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				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	20 9-89	Audited by:	40 9-89	Preliminary Approval:	
Date:	15-04-28	Date:	15/04/29	Date:	

H:\FORMS\Quality Assurance\approved QA\FAI revE

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

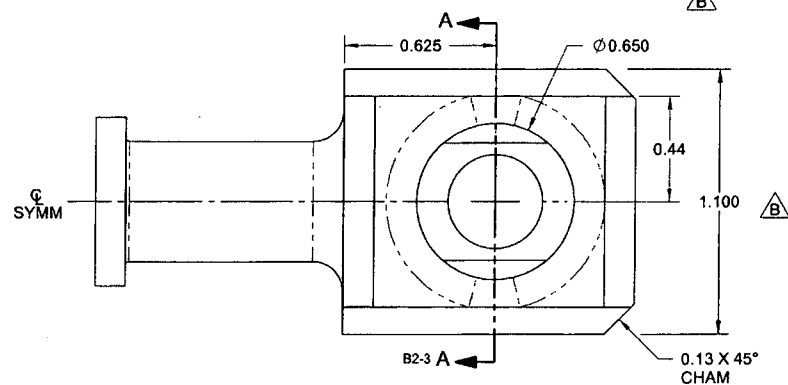
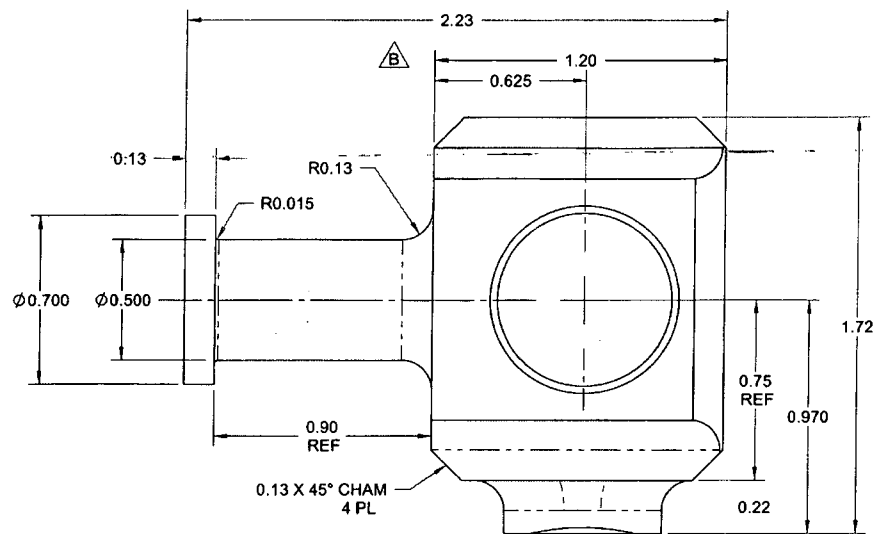
RELEASED
2010-07-16

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	1.5		
DRAWN	8/1		
CHECKED	8/1		
MFG. APPR.	8/1		
APPROVED	8/1		
DE APPR.	8/1		
DATE	10.06.28		

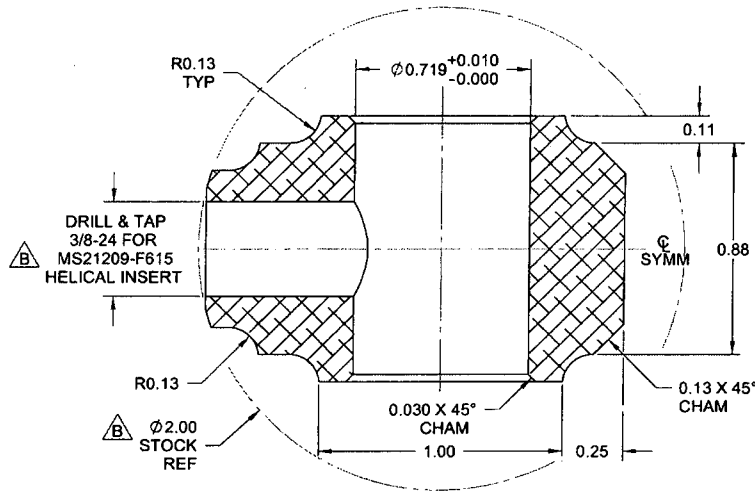
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. B
TITLE **EYEBOLT RECEIVER ASSY** SHEET 1 OF 3
SCALE NTS

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D3912-1 EYEBOLT

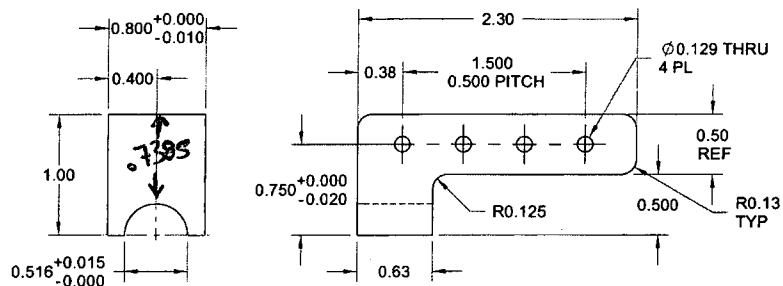


SECTION A-A B6-3

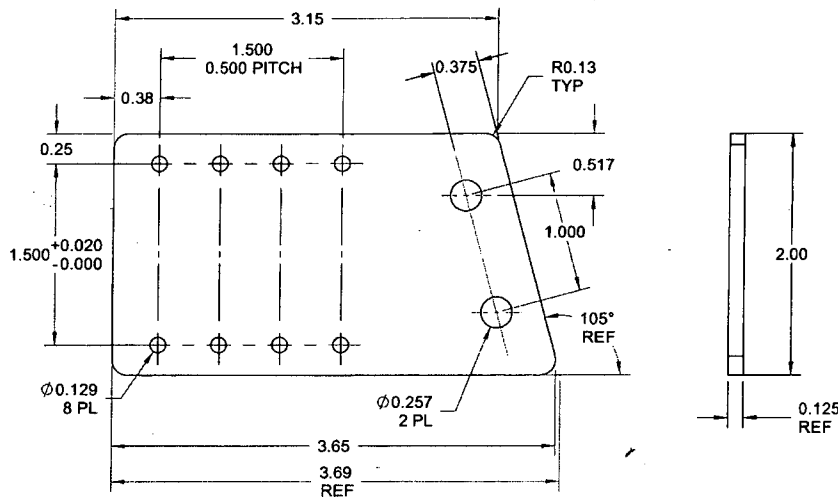
RELEASED
2010-07-16

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ID AT ASSEMBLY
 - 7) WEIGHT: 0.45 lbs

DESIGN	ASS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JL	DRAWING NO.	REV. B
CHECKED	JL	D3912	SHEET 2 OF 3
MFG. APPR.	JL	TITLE	SCALE
APPROVED	JL	EYEBOLT RECEIVER ASSY	NTS
DE APPR.	JL	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	10.06.28		



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-07-16

DESIGN	A/S	DART AEROSPACE LTD	
DRAWN	8/1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	8/1	DRAWING NO.	REV. B
MFG. APPR.	8/1	D3912	SHEET 3 OF 3
APPROVED	8/1	TITLE	SCALE
DE APPR.	8/1	EYEBOLT RECEIVER ASSY	
DATE	10.06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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